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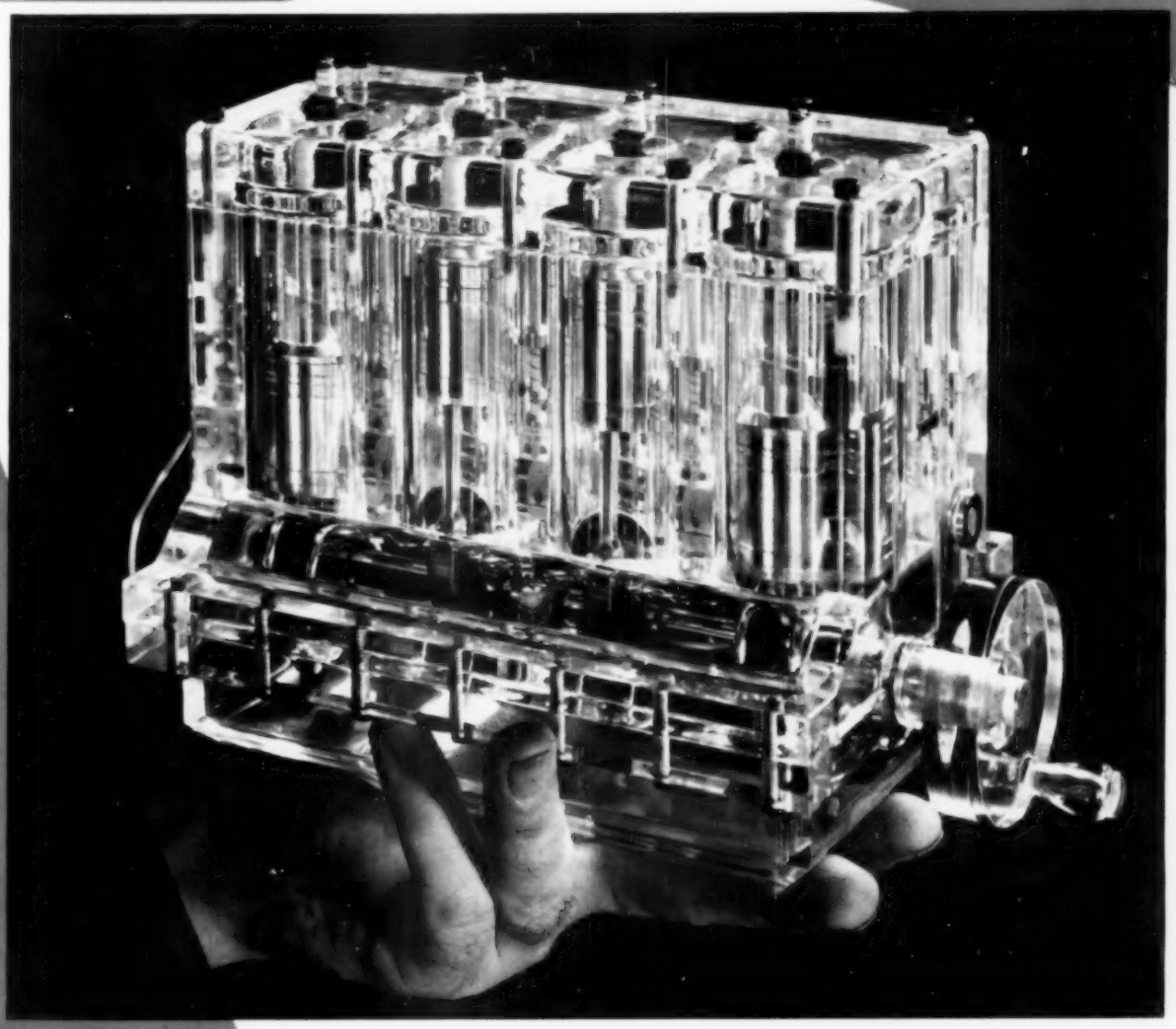

This hand-made handful is an accurate scale model of a four-cylinder automobile engine, fabricated of the acrylic plastic Plexiglas by Philip A. Derham and Associates, Incorporated, of Rosemont, Pennsylvania, for visual study purposes. Plexiglas is a product of Rohm & Haas Company, Philadelphia.

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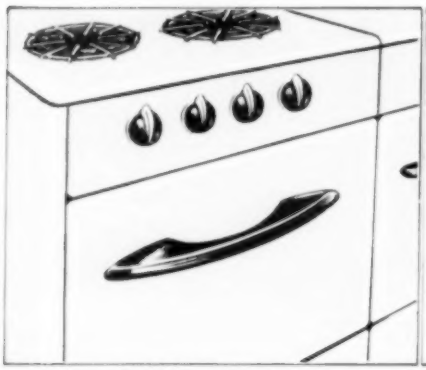
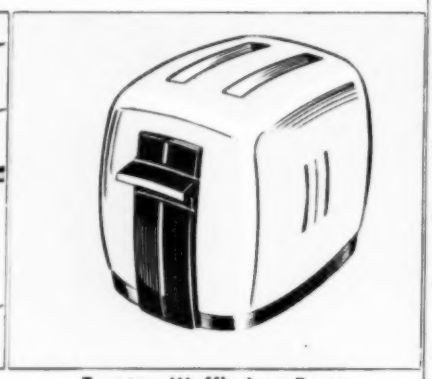
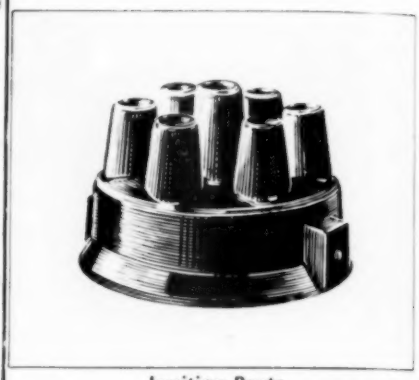
FOR PRODUCTS THAT RUN *a Fever*



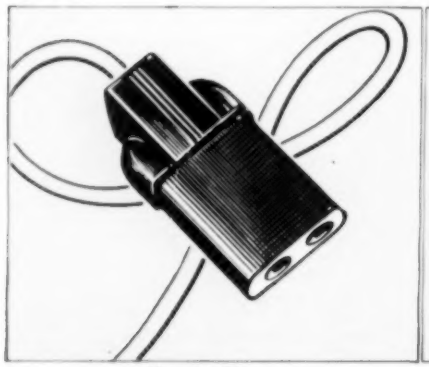
Stove Hardware



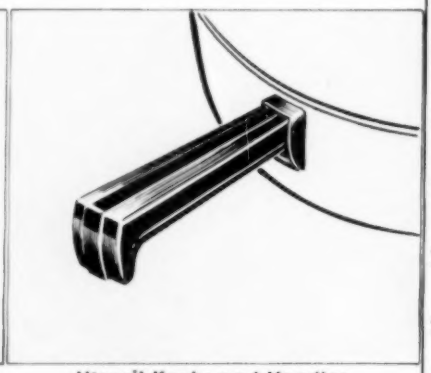
Toaster, Waffle Iron Parts



Ignition Parts



Heater Plugs



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The Society of Plastics Engineers Journal is not responsible for the views expressed by individual contributors. Copy for each issue should be received at 409 Security Bank Bldg., Athens, Ohio, before the fifth of each month.

The President's Corner

The Society of Plastics Engineers was represented by their President at the opening of the FESTIVAL OF BRITAIN in London on Thursday May 3.

Considerable interest was displayed by the various government officials and plastic men of Great Britain regarding our Society of Plastics Engineers.

Since your President has only just returned from visiting the Paris exhibition and the British "FESTIVAL OF BRITAIN" and is unable to accept the invitation of the British Plastics Federation to attend the British Plastics Exhibition in London, however, Charles Breskin has kindly consented to represent our Society at this affair.

The National Council meeting held in Chicago on May 10 was well attended and in my opinion was one of the best attended National Council meetings which we have ever held.

Islyn Thomas

$50.00 $50.00

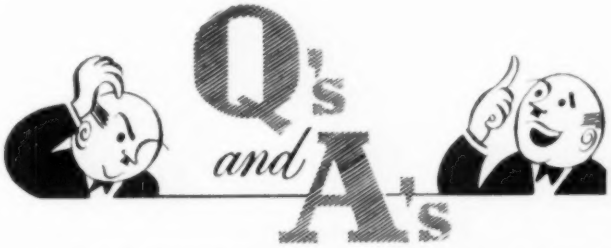
SPE PIN DESIGN CONTEST

Problem: To design a plastics based pin for use by SPE members. Must be readily molded or fabricated of plastics. May use plating, lacquers or other finish materials. Should be suitable for use as letterhead design, advertising and for similar purposes.

Deadline: Entries must be postmarked not later than midnight, September 30, 1951.

Entries should be sent to:
Pin Design Contest
Society of Plastics Engineers, Inc.
Athens, Ohio

The decision of the judges will be final.



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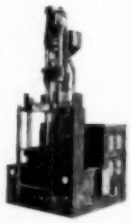

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Penn Notes

By Paul Roche

"The picking up loose ends department"—Although it has not been specifically recorded in that bible of the plastics industry, The SPE Journal, the 1951 officers of the Northwestern Pennsylvania Section have long since been elected and functioning actively. The new section president is William C. Conroy popular and active Plastics Division Sales Manager at Erie Resistor Corp. Bill has things well under control and, among other things, gave me the continued privilege of preparing this column.

The new officers were installed at the February meeting at the Yacht Club in Erie, on which occasion we were given a talk on "Plastics in Defense" by Mr. E. S. Childs of Monsanto Chemical Co.

In March we joined the local section of The American Society of Tool Engineers, travelling to Buffalo for a joint meeting with the Buffalo Section of the ASTE for a tour through the Colonial Radio Division of Sylvania Elec. Prod., Inc. Out of 250 attending, Ed Roberts (Gen. Elec. Co.) and Fred Oberkircher (Nosco Plastics), travelling together from Erie, nabbed the two door prizes in the form of table radios. The entire program was the hospitality of Sylvania.

In April "Ren" Morse (Injection Molders Supply Co—Cleveland) spoke to us on current tips for injection molders. This meeting was held at Pulakos-on-the-Lake in Erie.

On the call down at Warren, Penna. the other day I found John Specht nicely and busily operating as the injection molding specialist at Sylvania Electric Products, who are expanding their plastics department in general and, in particular, building an injection department from scratch. John is well known locally for his keen interest and activity in The SPE, having been connected with Erie Resistor Corp. for 15 years.

It is noted that Byrd Tool and Mold Co. is making an addition to its almost new plant, which will increase floor space by 30%. William R. Byrd, proprietor, makes it a policy to keep pace with the needs of the injection molders, local and foreign, by adding the larger machine tools and equipment to handle the increasingly larger molds being used in the industry.

Our thoughts now turn fondly to the prospect of a summer outing for section members (on the treasury yet).

See you in the Fall—have a swell vacation.

Hydraulic Equipment Maintenance Described at New York Meeting

By A. M. Merrill

A talk on "Hydraulics in the Plastics Industry," by E. O. Clark, manager of industrial products sales, Vickers, Inc., Division of Sperry Corp., featured the May 16 regular dinner meeting of the New York Section, held at the Hotel Shelburne and attended by some 50 members and guests of the group.

Mr. Clark noted that hydraulics have come into universal use, despite the availability of other methods of utilizing power, because no other medium combines the same degree of positiveness, accuracy, and flexibility of control with the ability to transmit a maximum of power in a minimum of bulk and weight. Using slides to illustrate his talk, the speaker discussed the design and operating principles of the hydraulic system in an injection molding machine, both single and two-stage hydraulic pumps, variable delivery pumps, hydraulic motors, and hydraulic transmissions.

The second portion of the talk was devoted to the need for proper maintenance of hydraulic equipment. A recent analysis of service calls to customers' plants showed the following approximate distribution of causes for failures: 70% due to improper condition of the hydraulic oil; 10% due to improper diagnosis of the trouble and insufficient knowledge to make proper repairs; 10% due to mechanical failures; 5% due to operating units beyond recommended limits on speed, pressure, or volume; and 5% due to miscellaneous causes.

Mr. Clark emphasized that a proper maintenance program on hydraulic equipment should embody the following aims: (1) Recognize that the user of hydraulic equipment has more control over maintenance than the manufacturer, and use this control effectively to reduce down-time; (2) Standardize on one make of hydraulic equipment for all machines in the plant in order to centralize responsibility for maintenance, secure better trained maintenance men, and eliminate the problems presented by the non-inter-changeability of hydraulic units or parts made by different manufacturers; (3) Maintain a stock of spare hydraulic parts and units to avoid down-time during repair periods; (4) Before buying a hydraulic machine make certain it will meet both your production and maintenance requirements; (5) Use the best hydraulic oil available, keep it in good condition, and change it as often as necessary; (6) Instruct the machine operator on the functions and limitations of the hydraulic equipment in his machine; (7) Select good men for the hydraulic maintenance staff and train them as specialists; (8) Set up a planned program of systematic preventative maintenance for your hydraulic equipment; (9) On actual repairs, analyze and isolate the trouble before dismantling any part of the hydraulic circuit; and (10) Make use of the repair or service department of the hydraulic equipment manufacturer on any maintenance problem you are unable to handle.

In a brief business session preceding the talk, reports were heard from president George Baron, Ideal Plastics Corp.; secretary-treasurer Arthur L. GeWertz, manufacturers representative; program chairman Winslow A. Ward, American Cyanamid Co.; prizes and favors chairman Richard Stott, Stott Tool & Machine Co.; and a report on the recent national directors meeting by Stanley Bindman, Jamison Plastics Corp. Table favors in the form of ball point pens were distributed through the courtesy of Mr. GeWertz, and the meeting closed with a drawing for valuable door prizes donated by Crown Sanitary Products, Inc., and Brilhart Plastics Corp.

Mr. Baron announced that the next regular dinner meeting of the Section, the last before the summer recess, will be held on June 20 at the Gotham Hotel. Featured speaker will be Frank G. Helander, Watson-Stillman Co., who will discuss "Large Injection Presses."

Continuing the Section's steady growth, the following five members have been added during the past month: John Egnatski, Allied Molding Corp.; Frederic H. Batke, Allied Molding Corp.; Bernard B. Levine, Moulding Corp. of America; Abb L. Scarbrough, National Lead Co.; and Charles Arliss, Premier Plastics Co.

Chicago Plans Summer Program

By Tim Serrell

The last regular joint plastics meeting of the season was held Wednesday evening, May 9, 1951, at the Builders Club, 228 No. LaSalle St., Chicago.

Everyone is urged to get out to the three golf outings, one each during the months of June, July and August:

Friday, June 15th—River Forest Golf Club, Elmhurst, Illinois. Tuesday, July 24th—Rolling Green Country Club, Arlington Heights, Illinois. Friday, August 17th—River Forest Golf Club, Elmhurst, Illinois.

For further information regarding the joint SPE-SPI summer golf tournaments kindly contact the SPE Chairman of the Golf Committee Mr. Maurie Meltzer, Service Plastics, Inc., CHesapeake 3-7777. Set these dates aside. Plan to bring your customers. Invite your friends.

Mr. Edwin F. Bushman, General American Transportation Corporation, Chicago, Illinois, gave the May gathering a "General Discussion on Fiberglas". All who attended came away from this meeting better informed on this fast-growing segment of our plastics industry.

Mr. Joseph Healy, Sales Manager of Manco Products Company, Melvindale, Michigan, covered, in the absence of Mr. M. A. Nichols, President, the question "Why Beryllium Copper?". Mr. Healy offered to send his company's brochure on the subject to all interested parties.

Mr. Elmer E. Mills, of Elmer E. Mills Corporation, gave an informal report on the styrene picture. The news that benzene will be obtained from the petroleum industry eventually in quantity was heartening.

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Molding Theory Is Topic at Newark
Prize Paper Contest Rules Are Outlined

By Anthony Naturale

The Newark Chapter of the Society of Plastics Engineers met at the Military Park Hotel, Newark, New Jersey on Wednesday, May 9, 1951.

Our President, Mr. Pete Simmons, asked Wally Gryce, Co-Chairman of the golf outing committee, to remind the members that the outing and golf tournament would take place on June 7, 1951, at the Canoe Brook Country Club, Summit, New Jersey. This event will mark the end of our activities until September.

Another important announcement regarding the prize paper contest was made by Mr. Don Biklen, winner of the 1948 prize paper contest. Mr. Biklen pointed out that this years contest is open to members and non-members alike, and that the deadline is October 15, 1951. He also mentioned that there is no ruling on the length of the paper and that any topic related to plastics may be chosen by the writer. Five copies of the paper should be sent to the Committee for their review.

Table favors for this meeting were donated by Kaye Plastics, Inc. Door prizes were donated by Shaw Insulator, Buxon Molding & Industrial Synthetics.

At this point of the meeting, we deviated from the usual procedure and were entertained by Mr. Henry Wies, of the Dow Chemical Company, who proved again that the hand is quicker than the eye with his feats of magic.

The Speaker of the evening, Mr. Robert W. Van Sickle of the Plastics Technical Service of Dow Chemical Company, gave an interesting talk on research and application in the injection molding of polystyrene.

For many years, we have wondered and guessed as to what happened when plastic material was injected into a cavity. An attempt to measure the pressure inside the mold was made in 1946 when E. E. ZIEGLER designed a pressure measuring mold. This mold made use of an oil actuated pressure gauge. The reading on the gauge was obtained by exerting pressure on a plunger fitted into the mold in such a manner that the plastic material pushed the plunger against the oil in the gauge chamber. This was later improved by the use of an electronic strain gauge which recorded plastic pressure during the entire molding cycle. After reviewing the above, Mr. Van Sickle showed us a movie taken in a quartz mold showing the injection of a low molecular weight polymer. This movie showed how material can be packed into a cavity and how material can leak back from the cavity through the gate if the injection pressure is released before the gate freezes. The amount of material drawn back can be reduced by using pin points or restricted gating but will not be completely eliminated by the use of smaller gates. Mr. Van Sickle also reviewed the latest development of a ball-Check nozzle which can completely seal off the material flow at the proper time preventing packing or flow back of material. These studies proved beyond doubt that the sealing pressure is a very critical factor in producing strain free moldings.

New Members Announced at the April Meeting were:

John Fontinelli of FIBRO CORPORATION and Frank Lefand of THOMAS MANFACTURING CORP. Mr. Edward Rowan of Dillon & Beck has been appointed Chairman of the National S. P. E. Speakers and a member of the Publications Committee. Newark Section Members appointed to the above Committees are: Mr. Joseph Bonanno of Lionel Corporation, Mr. Albert Kaufman of Industrial Synthetics, Mr. Carl Frosch of Bell Telephone Laboratories, Inc. Mr. Anthony Naturale of Thomas Manufacturing Corporation, and Mr. Islyn Thomas of Thomas Manufacturing Corporation.

Miami Valley Makes Visit to Plant of Dayton Rubber Co.

By John L. Russell

A dinner at Neil's Restaurant preceded the May 17 meeting of Miami Valley Section SPE. Afterward Program Chairman Carroll Jensen arranged a tour through the Dayton Rubber Co. plant where company guides conducted our members through the various manufacturing departments fabricating tires, tubes, belts, etc. A movie on tire making was also shown. Several of our lucky members including never-miss Dick Bice, won small foam rubber pillows in the complimentary door prize draw. Smokes and refreshments were also provided by the Dayton Rubber Co., at the conclusion of the tour. Our fullest thanks are extended to the Dayton Rubber Co., and their representatives for the evening, for their fine hospitality.

The next and last big event of the year is the 5th Annual Summer Picnic which is slated for Friday, June 29 at Terrace Park Country Club at Milford, O. Jack Baxter, Terrace Park Club member again made arrangements for securing the Club and is acting as co-Chairman with Merle Nelson in planning the picnic. Also assisting on the Committee are the Officers, Martin Kasch, Byron Nelson, Carl Weber and Charles Selz and Chester Kruger. There will be the usual golf, and other games of sport in the afternoon followed by a Buffet Supper.

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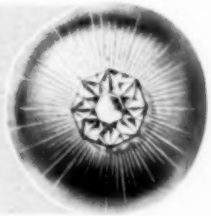

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New England Social Event Precedes Summer Vacation

By R. W. Crawford

The Western New England Section held its annual dinner dance on May 4 at the Hotel Sheraton in Springfield, Mass. The evening began with a Sheraton smorgasbord dinner at approximately 7:30 P.M. About fifty-two couples attended. Attractive favors, consisting of a comb and brush set in a zippered case, were given each lady. At the end of the dinner, seven or eight door prizes were given to the lady holding the lucky tickets.

The couples in the picture, reading from left to right, are: Mr. and Mrs. Sherwood Young, Mr. and Mrs. Edward Vaill, Mr. R. Crawford and Miss Kay McLaren, Mr. and Mrs. Emil Marciniak. The last three members constituted the dance committee.

Personals

A. M. Katz has been elected chairman of the board of directors of Ideal Plastics Corp., Hollis, N. Y. He is also treasurer and general manager of Ideal Toy Corp. Mr. Katz has named **Alfred C. Manovill** and **Lionel Weintraub** vice presidents, with Manovill assuming the duties of general manager of the industrial molding program.

Sundberg-Ferar, industrial designers at 3157 Guardian Bldg., Detroit, Mich., have been retained as design consultants for the Lighting Division of Sylvania Electric Products, Inc.

Richard C. Emmons, district sales manager of Detroit branch, United States Rubber Co., has been appointed sales manager of Koylon foam mattresses and pillows, U. S. rug underlay and U. S. non-slip in the company's national branch sales organization.

Continental Carbon Co. announced the appointment of: **Harry L. Ericson** as Chief Chemist of their new Amarillo Laboratory, 1440 W. 10th Ave., Amarillo, Texas.

T. A. Ruble as Technical Supervisor of the laboratory.

Clement A. Damen has been appointed manager of Witco Chemicals Company's Washington, D. C. office located at 1111 Seventeenth St., N.W.

Patrick Dolan, sales engineer of The Patterson Foundry & Machine Co., East Liverpool, Ohio, has been named district manager of their new Baltimore, Md., office at 1605 Court Square Building.

THE *Injection* MOLDERSCOPE

By A. R. MORSE

Injection Molder's Supply Co.

Color Dispersion in Injection Molding:

There is certainly every reason to investigate color dispersion or home-dyeing of thermoplastics, although occasionally one hears of injection molders who get more colors than crystal on their allotments. But it won't hurt to sum up a few facts on this vital matter. First, if you start with a regular clear granule you probably won't get the results (i.e. opaqueness) you would if you used the so-called colorant grinds. The colorant grinds are rougher and of irregular particle size so the color or pigment **can** adhere to the fractured surfaces. And the surfaces are treated with a wetting agent so they **will** adhere. Therefore if you are forced to use ordinary granules, tumble with the wetting agent for 10 min. and then tumble at least 20-30 with the pigment. As the pigment makers like Ferro and Gering point out, tumbling is not just a matter of **mixing** the color and the plastic, but of actually using the granules as an abrasive agent to **grind** the pigment. It has helped to pass ordinary granules through a fine screen (1/8") grinder or hammer mill before adding the wetting and coloring agents if the colorant grind was not available. In any case best results are obtained when you use a tumbler designed for home-dyeing and not a makeshift tumbler or one adapted from another industry. There are at least three tumblers (including my own—commercial plug) if not more designed to give the correct abrasive action needed for proper thermoplastic dyeing by the dry color process. As a general rule, to avoid the problem of cleaning steel surfaces, injection molders prefer tumblers which handle regular fibre drums, not only to avoid drum cleaning, but to avoid handling and re-handling of the material with attendant spillage, chance for contamination, and exposure to moisture, etc.

We come now to the nozzle. There are many expert opinions on just the right kind of nozzle for color dispersion — and I note a few patented (?) nozzles are being advertized. Various types of spreaders are on the market such as straight-drilled plugs for inserting in the back of the nozzle, or angle drilled plugs; or relieved plugs giving a multipinpoint effect. Or a spreader which sits under the nozzle seat and also fits down inside the nozzle; or a threaded plug which passes the material around spiral grooves cut on the outside of the metal insert inside the nozzle. I have made — and of course make — all types of color dispersion nozzles, but when it comes to evaluating the whole problem and giving an "expert" (?) opinion of my own, I can only say that I have observed so many successes and so many failures with every known type of dispersion plug that I do not know just which one is really best. Some work better for one molder than for another, and I have begun to suspect that a lot of other things besides color dispersion nozzles are the final determining factors in just how good color dispersion you get.

Particle size of the powder has a good deal to do with it. The kind and amount of tumbling is important. The amount of lubrication (stearate) externally added also affects dispersion. Heater design likewise enters in, some heaters giving different patterns than others. Heater temperatures and the size of the shot also affect it. In other words if you are running an 8 oz. job on an 8 oz. machine you will get a very different dispersion from that obtained running a 3-4 oz. job on the same machine. Pressure and time cycle are relatively unimportant, but gating has a great deal to do with it. Use of hot runners also affect it. Injection speed and plunger speed as mechanically controlled by the injection machine plunger speed control and as physically controlled by runner and more particularly gate size and location both definitely affect your ultimate dispersion. If the gate is parallel to or at right angles to a flat surface, this will also affect dispersion. So color dispersion is a whole problem, and the right answer often lies in some factor no one else has thought of before. The changes in pigments that are resulting from current shortages and substitutions are also going to affect our industry. Some of us who are beginning to think we know a little about home-dyeing are going to realize it is a little more involved and complicated than we have been led to think. But whatever our temporary problems with the process are, it is here to stay and will have resounding repercussions on the injection field, right up to and through injection machine and injection heater design.

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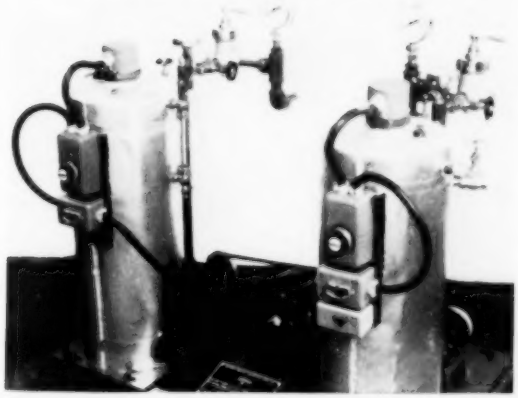

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What's New?

MATERIALS

SPECIFICATIONS CHART

Synthane Corp., Oaks, Pa., has prepared a handy table which correlates their products with all systems of grade specifications as drawn up by industry and by the various government agencies. The 8½ x 11 inch folder is available without charge.

STABILIZER FOR VINYLS

Laboratory testing by the Resinous Products Division of Rohm & Haas Co., fortified by actual field results, indicates that Paraplex G-60 exerts a definite stabilizing action in addition to its primary function as a plasticizer. Polyvinyl chloride films plasticized with this resin and containing no stabilizer whatever show good stability, though the addition of some supplementary stabilizer is generally recommended. It has been demonstrated that the presence of G-60 as a plasticizer permits the quantity of the stabilizer to be halved, even for the most rigorous conditions of processing and exposure.

MACHINERY

NEW INJECTION MACHINE

The Pre-Mill Plastics Machinery Div., National Electric Welding Co., 1846 N. Trumbull St., Bay City, Mich., announce the availability of their new line of plastics injection molding machines built around a newly-designed pre-milling unit.

EQUIPMENT & SUPPLIES

LUBRICANTS

Merix "Mold-Ease Concentrate PCR, a new, powerful and water soluble, mold lubricant, assuring quick release of molded plastic, ceramic & rubber articles shows the following characteristics: Effective release; Dies live longer, Enhances finish; Diversified applications; High concentration equals low cost. Merix Chemical Co., 1021 E. 55th St., Chicago 15, Ill., will furnish complete information upon request.

Injection Molders Supply Co., Penton Bldg., Cleveland 13, Ohio, have mold lubricants available in aerosol dispensers or refillable atomizers. The IMS Silicone Type and IMS Liquid Stearate Type are in the Aerosol dispenser. The IMS Powder Atomizers come packed with a zinc-calcium stearate mixture and may be easily refilled with any type sterate or sterate mixture.

RUBBER-FABRIC DRUM

United States Rubber Co. has developed a new 55 gallon synthetic rubber-fabric drum, suitable for shipping liquids, which can be collapsed after emptying, is returnable and reusable. 2500 collapsed drums can be shipped in the space that would hold only 300 rigid drums. Experimental tests indicate that the new drum will be suitable for shipments of oils, greases, fats, acids, paints, emulsions, soaps, dry powders and a variety of pharmaceutical and industrial chemicals.

ANTI-OFFSET

The Michael Lith Co., 145 W. 45th St., New York, 19, N. Y., have developed a new device called the Anti-Offset Jobmaster, which sprays a very fine powder on every sheet that comes out of the Multilith or Davidson duplicating machine. It allows the use of coated and card stock with out the offsetting usually present.

NEW LABELS

Krieger Color & Chemical Co., Inc., 6531 Santa Monica Blvd., Los Angeles 38, Calif., have a newly designed four color labels which will speed the identification of type and color of the colorant in their containers.

DUST CUPS

The F. J. Stokes Machine Co., Philadelphia, Pa., have neoprene dust cups available to users of rotary tabletting machines. The cups, easily attached to each upper punch, catch running oil or grease on the punch shank and keep it from falling into the granulation. Their use reduces maintenance work lubrication. Cleaning is required only once or twice weekly, and replacement is unnecessary because neoprene is not affected by oil or grease.

ON THE COVER

PLEXIGLAS ENGINE

Philip A. Derham and Associates, design engineers of Rosemont, Pa., recently made a four cylinder engine of acrylic plastic. The assembly, designed and fabricated to illustrate the close tolerances which could be held and the perfect visibility of working parts attainable in industrial models with this transparent material, measures about eight inches long, six inches deep and four and one-half inches wide.

SAINT LOUIS

By Dan Otto

The St. Louis Chapter of the Society of Plastic Engineers had their regular monthly meeting on Tuesday, May 22nd and we had as our speaker Mr. R. S. Morrison, President of the Molded Resin Fibre Co. of Ashtabula, Ohio. The subject of his talk was "Production Processes in Fiberglas Reinforced Plastics".

We had the largest turn-out of any meeting we have ever had and we had men here from as far as Wichita, Kans., to attend this meeting. It is my opinion that it was the outstanding meeting of the year.

Mr. Morrison is certainly an authority on the use of Fiberglas in combination with Plastics.

We think a word of commendation should go to our new member, Mr. R. J. Savage who is District Representative of the Owens Corning Glass Co. on the marvelous job he did of lining up the speaker, as well as putting in a tremendous effort to getting our attendance up to the high point of the year.

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